

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003849**Date Inspected:** 08-Sep-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lin Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Larry Viars was present to observe fabrication and perform Ultrasonic Testing (UT) Tower components, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Heavy Machinery Shop Bay 1:

The Caltrans QA observed welder stencil numbers # 040434, 066912, 048784 and 066674 performing semi automated Flux Cored Arc Welding (FCAW) fill passes in the 2G position on Tower Skin Plate D Longitudinal Stiffener Partial Joint Penetration (PJP) welds SSD1-SA17 A/G 8, 12, 34 and 38. QA observed ZPMC QC Lin Yang monitoring welding parameters and observed ZPMC personnel performing interpass cleaning prior to additional weld passes. The above mentioned welding appeared to be in general conformance with posted Welding Procedure Specification WPS-B-T-2332-TC-P5-F.

Heavy Machinery Shop Bay 2:

The Caltrans QA performed UT Verification testing of ZPMC Quality Control (QC) tested and accepted Skin Plate CJP welds, Skin Plate A welds ESD1-SA300 A/F 3 and 4, Skin Plate B weld ESD1-SA384 A/D 4 and Skin Plate E SA298 A/G weld 5. No relevant indications were noted during testing. See UT report TL-6027 generated on this date for further information.

The Caltrans QA observed welder stencil numbers # 066471 and 068864 performing semi automated Flux Cored

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Arc Welding (FCAW) fill passes in the 2G position on Tower Skin Plate C Longitudinal Stiffener Partial Joint Penetration (PJP) welds ESD1-SA80 D/E weld 15 and ESD1-SA296 A/E 23. QA observed ZPMC QC An Qing Xiang monitoring welding parameters and observed ZPMC personnel performing interpass cleaning prior to additional weld passes. The above mentioned welding appeared to be in general conformance with posted Welding Procedure Specification WPS-B-T-2332-TC-P5-F.

Summary of Conversations:

Only General conversations between QA and QC occurred this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ryan Smith, (858) 232-6799, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	Lanz,Joe	QA Reviewer
